



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-667-103
Job Sheet 182672



Part No: D206-667-103

Job Qty: 1 ea

Part Name: Fwd Crosstube - High 206L / L1 / L3 / L4



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/29/18

Job Tracking No:

Due Date: 9/21/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG DSI9565 REV A , DSI9628 REV A , D206-667-143 REV C (DEO) IPP Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM IPP Rev:G 08-06-03 update per DSI9415 (ECN1198) DD IPP Rev: H 08.11.17 QC5 was QC6 at step 12 KJ verified: EC IPP Rev:I 08-12-15 add magnobond DD verified:EC IPP Rev J 09.01.06 ECN 08-562 EC verified:DD IPP Rev:K 09-01-19 as per DSI9439 DD verified:EC IPP REV:L 11.08.05 PER ECN 11-615 DD VERF:EC IPP REV:M 12.08.20 DSI9628 revA (ECN12-631) DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/21/18	9/21/18	0.00	0.00	Start Up Crosstubes-1		
110	Packaging	1 pcs	9/21/18	9/21/18	0.00	0.00	Packaging1-2		
120	CNC Bend Crosstubes	1 pcs	9/21/18	9/21/18	0.00	3.03	CNC Bend Crosstube		
130	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC15		
140	Crosstubes	1 pcs	9/21/18	9/21/18	0.00	0.80	Crosstubes-1		
150	HandFXtube	1 pcs	9/21/18	9/21/18	0.00	0.31	HandFinish5		
160	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC7-1		
170	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC5		
180	Outsource	1 pcs	9/21/18	9/21/18			SKY002-VC		
190	Packaging	1 pcs	9/21/18	9/21/18	0.00	0.00	Packaging2		
200	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC5		
210	SprayPaint	1 pcs	9/21/18	9/21/18	0.00	0.25	Spray Paint		
220	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC14		
230	Crosstubes	1 pcs	9/21/18	9/21/18	0.00	1.54	Crosstubes-1		
240	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC5		
250	Packaging	1 pcs	9/21/18	9/21/18	0.00	0.00	Packaging1-2		
260	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC4		
270	Packaging	1 pcs	9/21/18	9/21/18	0.00	0.00	Packaging3-1		
275	DC	1 pcs	9/21/18	9/21/18	0.00	0.00	DC		
280	QC21-FG	1 Ea	9/21/18	9/21/18	0.00	0.00	QC21		

Part Op 120 - Bend tube as per Dwg D206-667-143 using CNC bender program

Descriptions: 140 - ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: ***** 1- Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes. Holes facing inboard. ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: ***** 2- Drill Fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-143. Note: Fwd side has 3x top holes.Facing inboard. 3- C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins .Drill ONLY 2 top holes ONLY plug most bottom holes to prevent accidental drilling. Drill holes and ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes. 5- Drill Aft rivet holes using drill Jig DT8787 aft as per Dwg D206-667-143. 6- C'sink holes as per Dwg D206-667-147. Allow rivet to sit below surface to compensate for paint. 7- Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143 Inside of Cuff (Do not engrave on outside of tube) 8- *** WEAR LATEX

P.T.O.

GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

150 - ***IMMEDIATELY AFTER GRINDING***

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

210 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** *** MASK AREA UNDER CLAMP PRIOR TO PAINTING AS PER DWG DEO*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per QSI 005 4.2 PRIME: 138872 Start Time: Finish Time: PAINT: 138949

220 - Wrap in plastic bag to protect from scratches

230 - 2-Install supports with Proseal 890 per D206-667-143 (DEO) and QSI 015 3-Install supports clamps Using Dt9565 as per Dwg D206-667-143 (DEO),Torque to 80-100 IN-LBS. 4-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

240 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

VERIFY RESISTANCE PER NOTE 18 AND DWG DEO

260 - ***VERIFY BY BATCH # TO MATCH W/O

270 - Identify and pack for shipping as per PPP D206-667-103 Location : FG103

275 - Photocopy bluefile and create labels as per PPP D206-667-103 CHG006

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D206-667-103TRN	Crosstube Turning Detaill	1 Ea (1 ea)	90-Start up Operation	158318
D2873-043	Nut Plate Assembly	2 Ea (2 ea)	230-Crosstubes	
D2873-045	Nut Plate Assembly	2 Ea (2 ea)	230-Crosstubes	
D2891-1	Support 2.25	2 Ea (2 ea)	230-Crosstubes	
D3595-063-395	Rubber Cushion 0.63" Wide X 3.95" Long	4 Ea (4 ea)	230-Crosstubes	
MS20601-AD4W8	Rivet	14 Ea (14 ea)	230-Crosstubes	
MS21920-20	Clamp	4 Ea (4 ea)	230-Crosstubes	
AN5-32A	Bolt	4 Ea (4 ea)	250-Packaging	5015691
AN5-7A	Bolt	4 Ea (4 ea)	250-Packaging	5058983
AN970-4	Bolt	10 Ea (10 ea)	250-Packaging	FM1233
AN970-4	Washer	12 Ea (12 ea)	250-Packaging	5016398
D206-667-017	Grounding Strap	1 Ea (1 ea)	250-Packaging	
Nut	Nut	4 Ea (4 ea)	250-Packaging	5043592
NAS1149D0563J	Washer	18 Ea (18 ea)	250-Packaging	5050052

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D206-667-103TRN 5049001	1	4	0
230-Crosstubes	D2873-043 5090584	2	89	0
	D2873-045 5050682	2	23	0
	D2891-1 5054584	2	20	0
	D3595-063-395 5037816	4	139	0
	MS20601-AD4W8 5033983	14	328	0
	MS21920-20 5034404	4	236	0
250-Packaging	AN5-30A	4	86	0
	AN5-32A	4	357	0
	AN5-7A	10	3,319	0
	AN970-4	12	150	0
	D206-667-017 5049001	1	13	0
	MS21042L5	4	1,054	0
	NAS1149D0563J	18	1,980	0

Part Specifications

Specifications coul

DART
AEROSPACE

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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-8200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S114758



Part: D206-667-103

Job No: 182672

Serial No/Batch: S114758

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH01-5 Issue 3, EAA 87, SR01304NY 05/12/15, JCAB JAI

Item	Qty	Part Number	Description
	-143		
1	X	D206-667-143	CROSSTUBE ASSEMBLY (208L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20607AD4W8	RIVET (OR NAS9302B-4-5)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION R80-12D-023
			ADHESIVE (TEXTRONBELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
- 2) FINISH: FINISHED LENGTH = 104.9830.020
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY.
- 10) TRANSITION SHOULD BE SMOOTH.
- 11) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 12) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 13) INSTALL D2891-1 SUPPORT USING 0.08" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 016. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 14) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 15) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. ORCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 16) TORQUE CLAMPS 80 TO 100 N-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

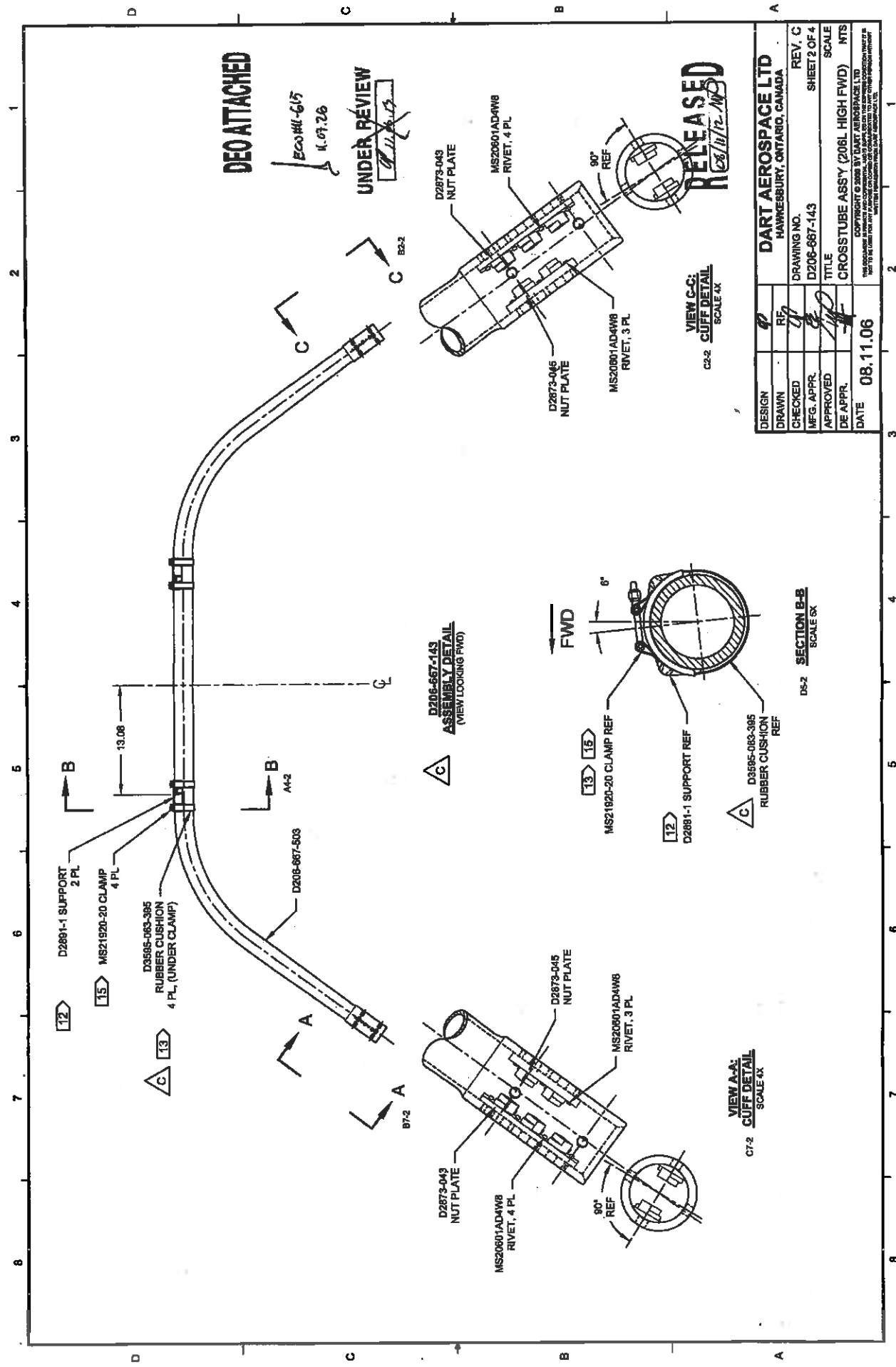
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 182672 MWS
180824

100 #1-615
11.07.26

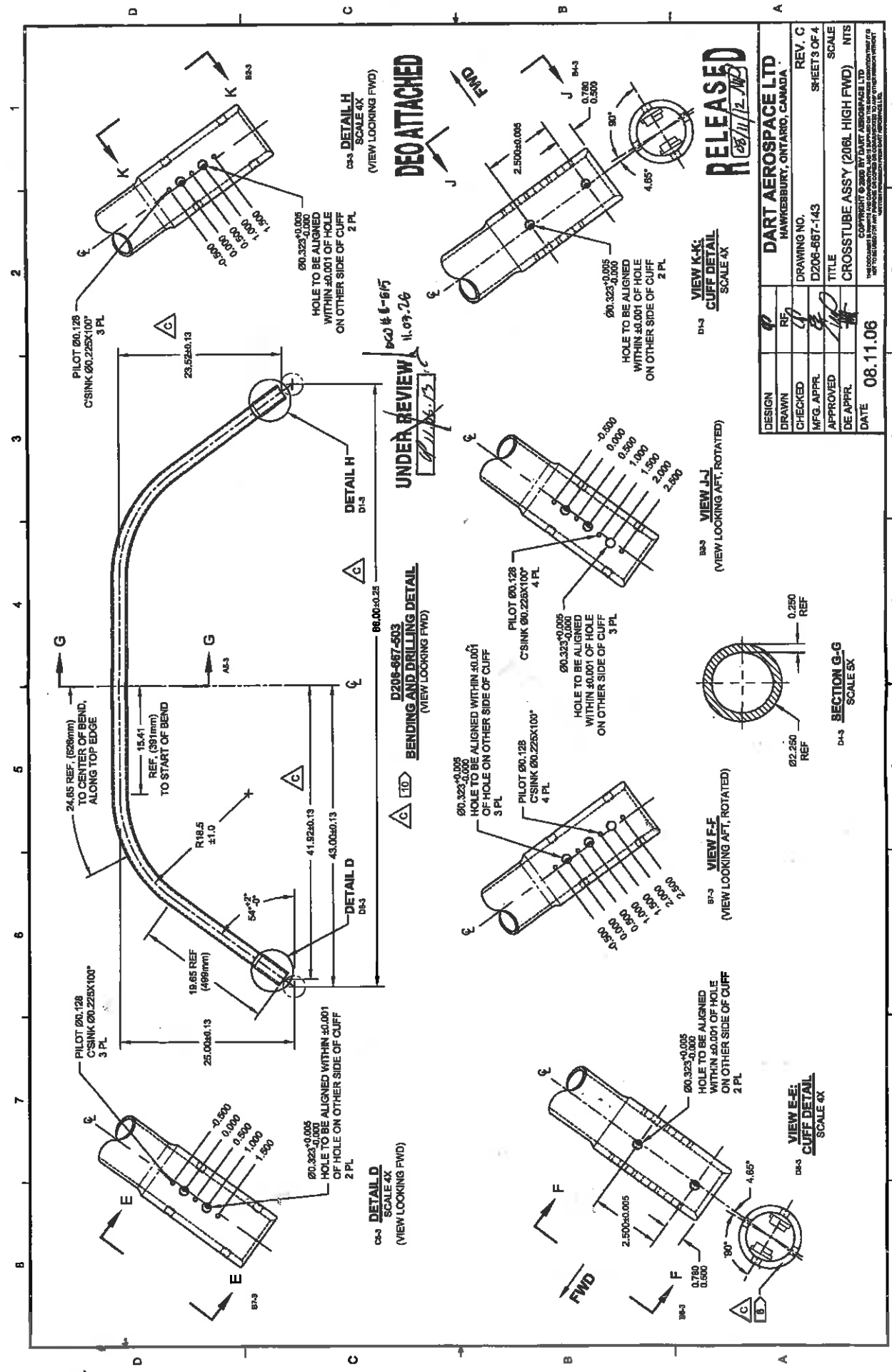
UNDER REVIEW
11/08/13

DEO ATTACHED
RELEASED
18/11/12

C	REVISE GENERAL NOTES/PART LIST (ZND73-1); REORDERED VIEWS AND REFORMATTED DRAWING TO CORRECT DIMENSIONS AND TOLERANCES CROSSTUBE WAS TOLERANCE 400-504 (ZND9-2 & AS-2); REMOVED REF. A ADD TOLERANCE (ZND9-3, C4-3, C5-3); RELOCATED FLAG #6 (ZNDAS-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BRITAIN SKIDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.06		
DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA		REV. C SHEET 1 OF 4	
CROSSTUBE ASSY (208L HIGH FWD)		SCALE NTS	
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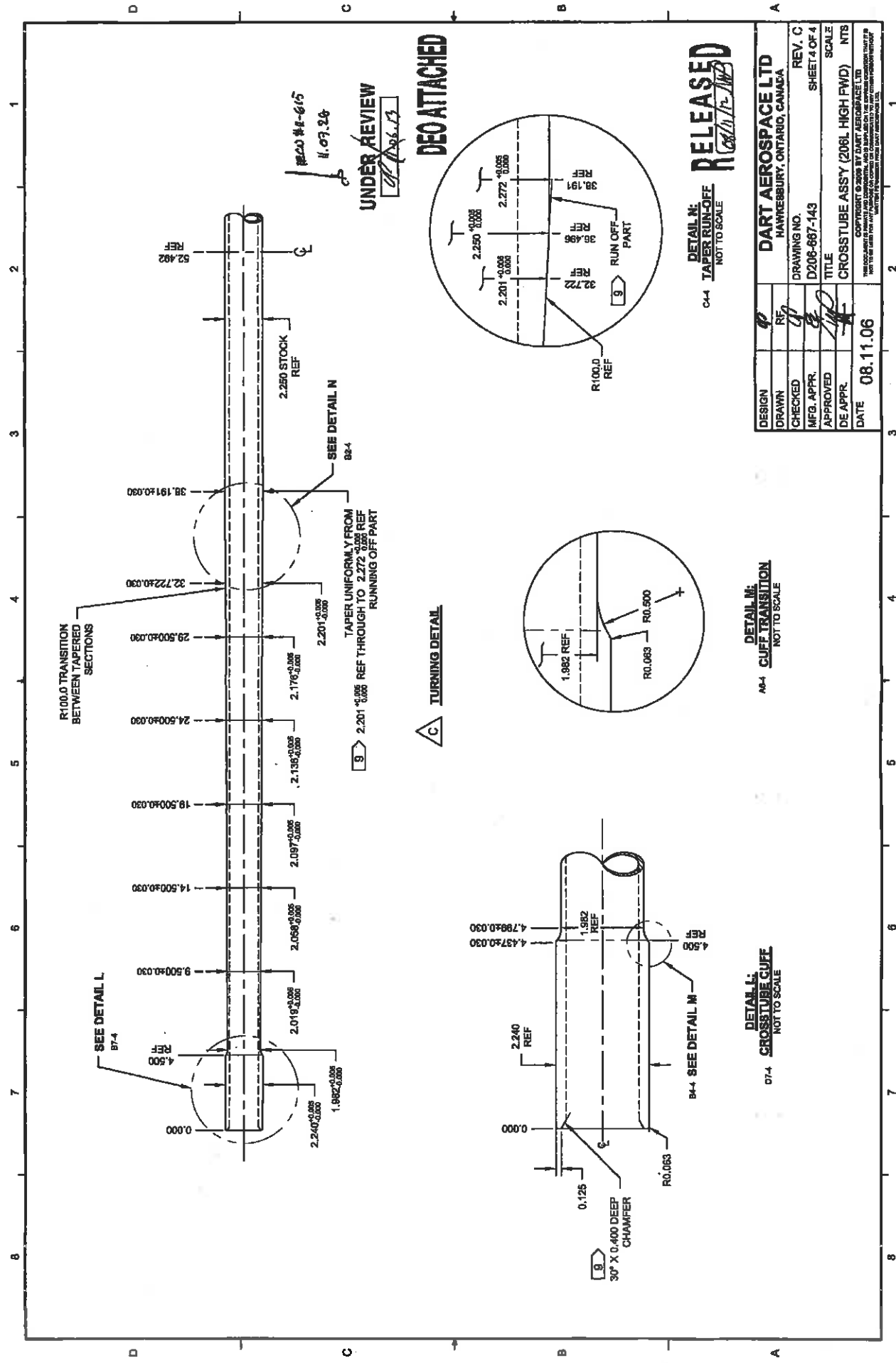


DESIGN	Q	DART AEROSPACE LTD		
REVISION	1	HAWKSBURY, ONTARIO, CANADA		
CHECKED	W	DRAWING NO.	REV. C	
APPROVED	W	D206-687-143	SHEET 2 OF 4	
DATE	08.11.06	TITLE	SCALE	
		CROSTUBE ASS'Y (206L HIGH FWD)	NTS	
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RELEASED
08/11/12 NCB

DESIGN	0	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RE	
CHECKED	17	
MFG. APPR.	2	
APPROVED	17	
DATE	08.11.08	REV. C SHEETS 3 OF 4 SCALE CROSS-TUBE ASSY (208L HIGH FWD) NTS D208-587-143 TITLE DART AEROSPACE LTD COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS LOANED TO YOU BY DART AEROSPACE LTD. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.



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DRAWING NO. D206-667-143	TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-143-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 90	CHECKED ASS		MFG. APPR. [Signature]	APPROVED [Signature]		DE APPR. [Signature]	
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11.07.21	DATE 11.07.21	DATE 11.07.21	DATE 11.07.21	

PURPOSE:
REPLACE MAGNOBOND WITH PROSEAL

CHANGE:

IS:

Item	Qty	Part Number	Description
9	A/R	PROSEAL 890 B-2	ISEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTURON/BELL SPEC. 298-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 8398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.6 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
[Signature]

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WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DRAWING NO. D206-667-143	TITLE CROSSTUBE ASSY (206L HIGH FWD)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D206-667-143-C-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	DATE 12.08.02	MFG. APPR. B	APPROVED AP	DE APPR. H	
DATE 12.08.02	DATE 12.08.02	DATE 12.08.02	DATE 12.08.02	DATE 12.08.02	DATE 12-08-02	

PURPOSE:

ADD ELECTRICAL GROUNDING STRAP

CHANGE:

PARTS LIST:

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
10	2	AN742D36	CLAMP
11	2	MS9165-05	ANGLE BRACKET
12	2	MS21042L3	NUT (OR MS21042-3)
13	2	MS27039-1-08	SCREW
14	4	NAS1149C0332R	WASHER (OR AN960C10L)

GENERAL NOTES:

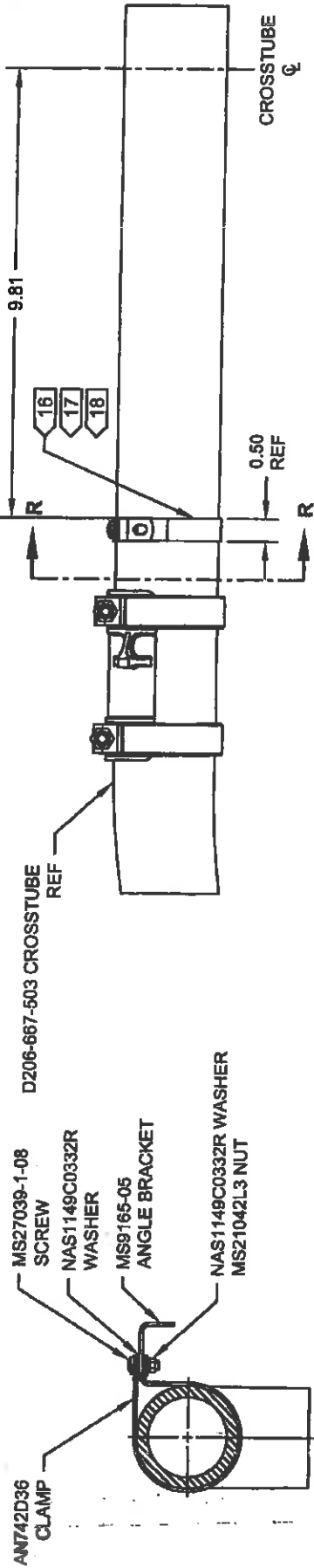
- 16) MASK AREA UNDER CLAMP PRIOR TO PAINTING
- 17) SEAL EDGES WHERE AN742D36 CLAMP MEETS WITH THE CROSSTUBE USING SIKAFLEX-241/-281 OR MIL-S-8802 CLASS B2 OR PROSEAL 890 SEALANT
- 18) PERFORM RESISTANCE CHECK TO ENSURE MAX RESISTANCE IS 10 MILLIOHMS

RELEASED

12.08.17

12-631

AFT



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Entered: _____ Date: _____

mid
26 July 2019



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7350

Route update only ☐

Job: <u>182672</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>2206-667-103</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Cross tube ☒ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: <u>18/9/17</u>	Sequence #: <u>130</u>	QTY Affected: <u>1</u>		MRB (QSI042) <u>1058</u> <u>12</u> <u>9/10/17</u>			
Description Work Order Deviation		Disposition		Completed By <u>19-7-22</u> <u>19-7-22</u>			
One width under tolerance after bending. 6.17 6.17 under nominal.		Acceptable. Overel width in tolerance, cross tube is even.		Lead hand / Supervisor <u>TW</u>			
Root Cause		FAULT CATEGORY		QC / QA Coordinator <u>DAS</u> <u>68</u> <u>9-89</u> <u>JUL 22 2019</u>			
Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO041267

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041267
PO Date: 10/5/18
Due Date: 10/9/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

REVISED
E-MAILED
OCT 09 2018

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181664	D350-748-103	AS350 / AS355 Stainless Steel Fwd Crosstube : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKY SERVICE:	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.855714/pcs	\$142.86
	181667			Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.855714/pcs	\$142.86
Sub Total:							2	0	2		\$285.71
2	181669	D350-748-203	AS350 / AS355 Stainless Steel Aft Crosstube : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKY SERVICE:	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
	181670			Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
Sub Total:							2	0	2		\$285.71
3	182672	D206-667-103	Fwd Crosstube - High 206L / L1 / L3 / L4 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO041267

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
	182673		OCT 09 2018	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
Sub Total:							2	0	2		\$285.71
4	182675	D206-667-103	Fwd Crosstube - High 206L / L1 / L3 / L4 TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
Grand Total:										\$1,000.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/9/18 11:03 AM dart.lavoie.chantal



Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO37683	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO041267 ✓
* Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	

Task: UNSCHEDULED	Sequence: 1
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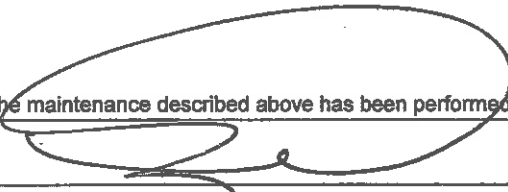
Work Required:

CARRY OUT NDT ON:

- / 3 FWD CROSSTUBES , P/N# D206-667-103 , J/S# 182672 ✓, 182673 ✓, 182675 ✓
- / 2 STAINLESS STEEL FWD CROSSTUBES , P/N# D350-748-103 , J/S# 181664 ✓, 181667 ✓
- / 2 STAINLESS STEEL AFT CROSSTUBES , P/N# D350-748-203 , J/S# 181669 ✓, 181670 ✓

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417 REV. 16						OCT 05 2018	
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: OCT 05 2018
Name: RAFIK MELIKIAN		